

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006627**Date Inspected:** 06-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1130**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Makhmud Ashadi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

On this date, 5/06/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections and their associated built up plate sections in the Fabrication shop #4, Japan Steel Works, Muroran, Hokkaido, Japan.

West Deviation Saddles:

W2E3 - Temporary attachments and weld tab extensions being removed by way of Carbon Arc process.

Assembled section will be laid down to allow for a 1G (Flat) weld of Cast stem to Plate stem.

W2W2 - Plate rib being welded to Base Plate, joint W2Y-9L by M.Kashiwada 08-2008, 50% complete. Plate rib to plate stem, joint W2Y-12V, is in process by welder T.Watanabe 08-5153, both welders are using Flux Core Arc welding (FCAW) process, 1.6mm weld wire and SJ3011-3 procedure.

W2W3 - Casting undergoing NDE process, Magnetic Particle (wet), by A.Seino #82.

Tower Saddles:

T1-3 - Two welders, K.Sadakawa 06-2929 and T.Ohkawa 03-91, are actively performing Shielded Metal Arc Welding (SMAW) process to deposit root pass of welds 9Y-10U and 9Y-9U using 4mm, E7016 electrode, per SJ-3012-4 procedure.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

Summary of Conversations:

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

No significant conversations to report on this day.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Brcic,Michael	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
